Item ID:	D3272-1		Accept	*N9000401∩0*	Setup	Start	*NS1*
Revision ID:							
Item Name:	Step					Stop	*NS2*

Start Date:	12/21/11	Start Qty: 10.00	*10*	Cust Item ID:		
Required Date:	12/28/11	Req'd Qty: 10.00	*10*	Customer:		

Reference:

					Run	Start	*NR1*
Approvals:	Process Plan:	Date:	Tooling:	Date:			
	QC:	Date:	SPC (Y/N):	Date:		Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D3272	Rev B								
100 *100* Large Fab Large Fab	Large Fab	0.00							
	Memo ***SQUARE ONE END BEFORE CUTTING OTHER END***	0.00					_10_	∅	
	1-Cut D2622-120 extrusion to 116.25" long as per Dwg D3272 using cutting table setup DT 8185-2A		*11·12·23*						
	2-Drill extrusion as per Dwg D3272 using Jig DT8680 for rivets.								
	3-Deburr								
110 *110* QC Quality Control	QC6- Inspect dimensions to drawing	0.00							
	Memo	0.00 *11/12/13*							*(411)*

Item ID:	D3272-1		Accept	***N9000040100***	Setup	Start	***NS1***
Revision ID:							
Item Name:	Step					Stop	***NS2***
Start Date:	12/21/11	**Start Qty:** 10.00	***10***	**Cust Item ID:**			
Required Date: 12/28/11		**Req'd Qty:** 10.00	***10***	**Customer:**			
Reference:							

					Run	Start	***NR1***
Approvals:	**Process Plan:** _____	**Date:** _____	**Tooling:** _____	**Date:** _____			
	QC: _____	**Date:** _____	**SPC (Y/N):** _____	**Date:** _____		Stop	***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 ***120*** Packaging	Identify as per dwg & Stock Location: *WA*	0.00							
Packaging	Memo	0.00	*R 11·12•23*			*10*	*∅*	____	____
130 ***130*** QC	QC21- Final Inspection - Work Order Release	0.00							
Quality Control	Memo	0.00				____	*11/12/28*		

R11-12-23

Picklist Print

December-21-11 10:33:34 AM

Work Order ID:	77797											
Parent Item:	D3272-1					Start Date: 12/21/11				Required Date: 12/28/11		
Parent Item Name:	Step					Start Qty: 10.00				Required Qty: 10.00		

Comments: IPP Rev:A   New Issue   07-06-09   JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2622-120C		Manufactured	No			100	Each	106.0200	1	10			
Step Extrusion											*Ae 11·12·21*		

Location	Loc Qty	Loc Code
HALL	17.02	
46910	2	
64409	6	
66970	7.7	
68293	0.5	
72131	0.82	
WA013	89	
75781	89	(X10)

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA

		DRAWING NO.	REV. B
		D3272	SHEET 1 OF 3

DATE		TITLE	SCALE
07.05.18		STEP ASSEMBLY, HI LONG	NTS

A	04.03.01	NEW ISSUE
B	07.05.18	D3272-1 WAS D2622-120

RELEASED

07.06.04

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	**STEP ASSEMBLY, HIGH LONG (LH)**
	X	D3272-042	**STEP ASSEMBLY, HIGH LONG (RH)**
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

⚠ B

GENERAL NOTES:
1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
2) WELD PER DART QSI 004
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
        POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
        BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
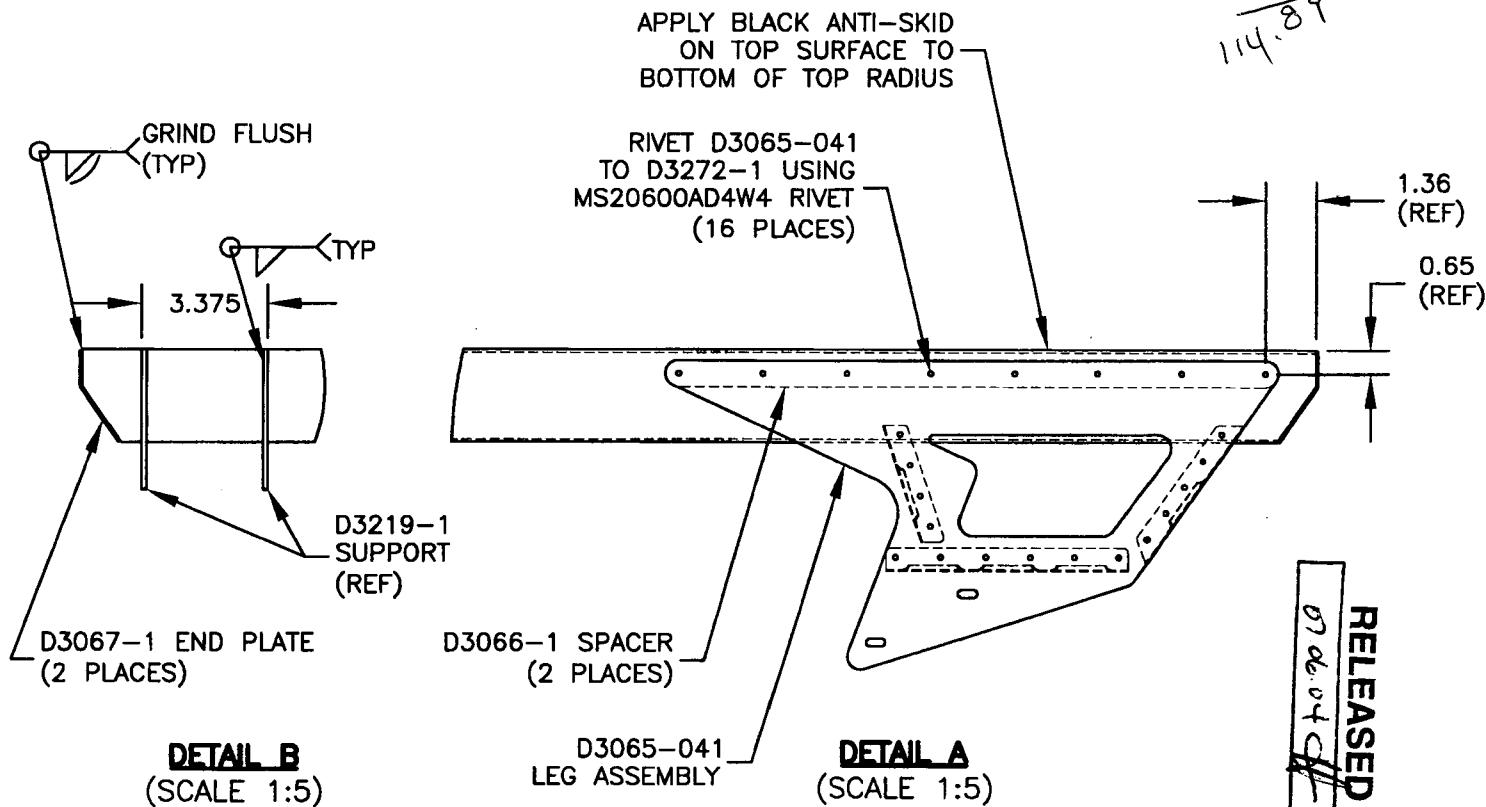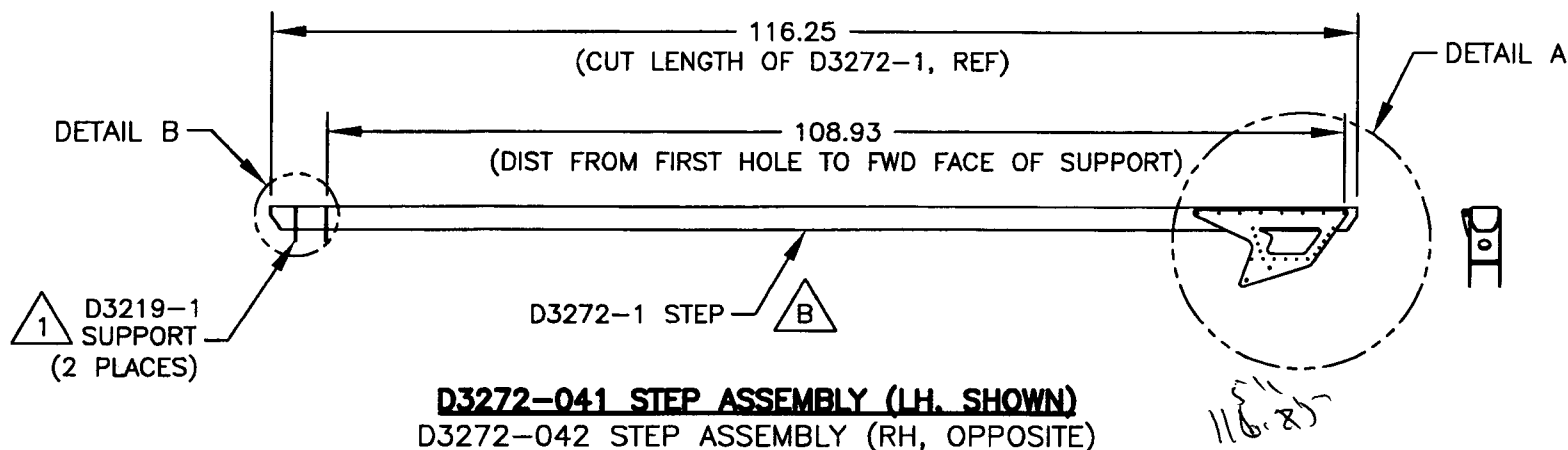6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

116.25
(CUT LENGTH OF D3272-1, REF)

108.93
(DIST FROM FIRST HOLE TO FWD FACE OF SUPPORT)

DETAIL A

DETAIL B

△1 D3219-1
SUPPORT
(2 PLACES)

D3272-1 STEP ─ △B

116.8
1.76
114.89

D3272-041 STEP ASSEMBLY (LH, SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)

GRIND FLUSH
(TYP)

TYP

3.375

APPLY BLACK ANTI-SKID
ON TOP SURFACE TO
BOTTOM OF TOP RADIUS

RIVET D3065-041
TO D3272-1 USING
MS20600AD4W4 RIVET
(16 PLACES)

1.36
(REF)

0.65
(REF)

D3067-1 END PLATE
(2 PLACES)

D3219-1
SUPPORT
(REF)

D3066-1 SPACER
(2 PLACES)

D3065-041
LEG ASSEMBLY

DETAIL B
(SCALE 1:5)

DETAIL A
(SCALE 1:5)

RELEASED

DESIGN

DRAWN BY

CHECKED

APPROVED

DATE 07.05.18

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3272   REV. B

TITLE STEP ASSEMBLY, HI LONG

SHEET 2 OF 3

SCALE 1:20

RELEASED

07.06.04

116.25
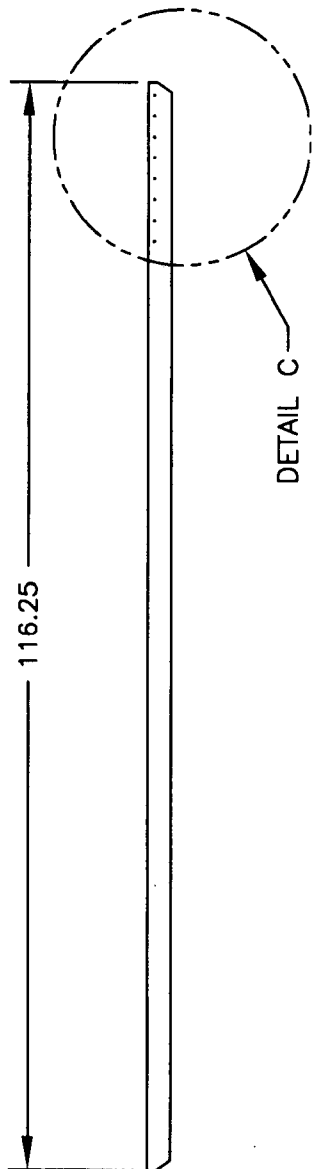
DETAIL C

⚠ B **D3272-1 STEP**

(MAKE FROM D2622-120 STEP EXTRUSION)

1.36 (REF)

1.00 (TYP)

35° (TYP)

15.75
8 HOLES EQ. SPACED
(2.25 PITCH, REF)

0.65 (REF)
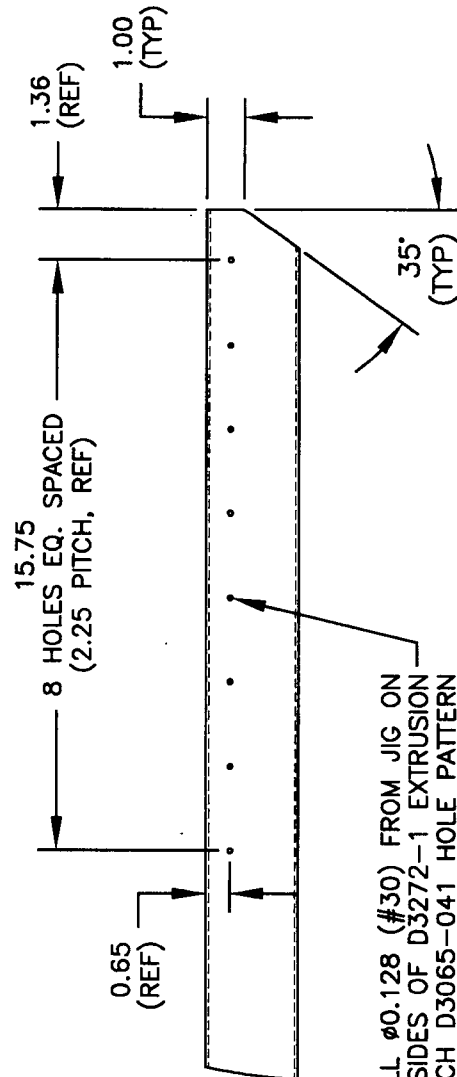
DRILL ⌀0.128 (#30) FROM JIG ON
BOTH SIDES OF D3272-1 EXTRUSION
TO MATCH D3065-041 HOLE PATTERN

DETAIL C
(SCALE 1:5)